

Work Order ID 61211

Wednesday, August 11, 2010 10:17:59 AM



Page 1

Item ID: D2877

Accept



Setup Start



Revision ID:

Item Name: Saddle Spacer

Stop



Start Date: 8/11/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 10-8-11

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2877	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2877 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-deburr

6061 . 125

10-8-17



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-8-17

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

41
counted
in 10's

1006-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									
150		0.00							
	QC3- Inspect Part Finish								
QC	Memo	0.00							
Quality Control									

N/A one 2 100

10 08 19 (41)

→ MY 10/08/19

41

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location 2p

0.00



Packaging

Memo

0.00

Packaging

10/06/23 4125

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/24 AF
CL1018124

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Picklist Print

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Parent Item: D2877



Parent Item Name: Saddle Spacer

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP B 00.05.19 Added inspect level 8 EC
 IPP C 06.04.26 Water jet EC
 IPP Rev:D Now M6061-T6 06-06-23 JLM
 IPP Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 		Purchased	No			110	sf	143.1600	0.0607	1.916842	2.5		
6061-T6 .125 Sheet											B 10-8-17		

Location

Loc Qty

Loc Code

MAT21

143.16

113608

96

114352

47.16

114352

411

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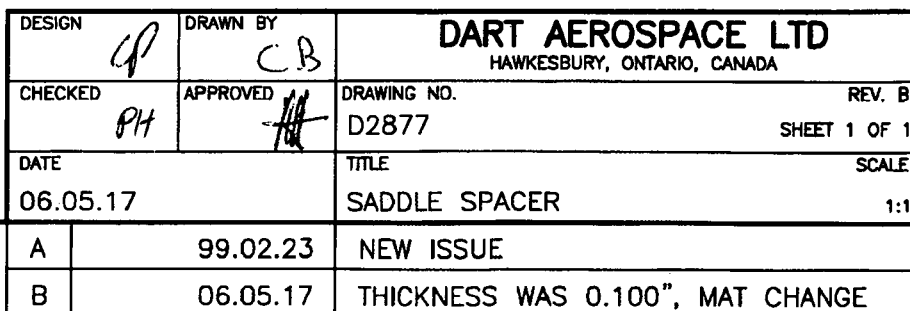
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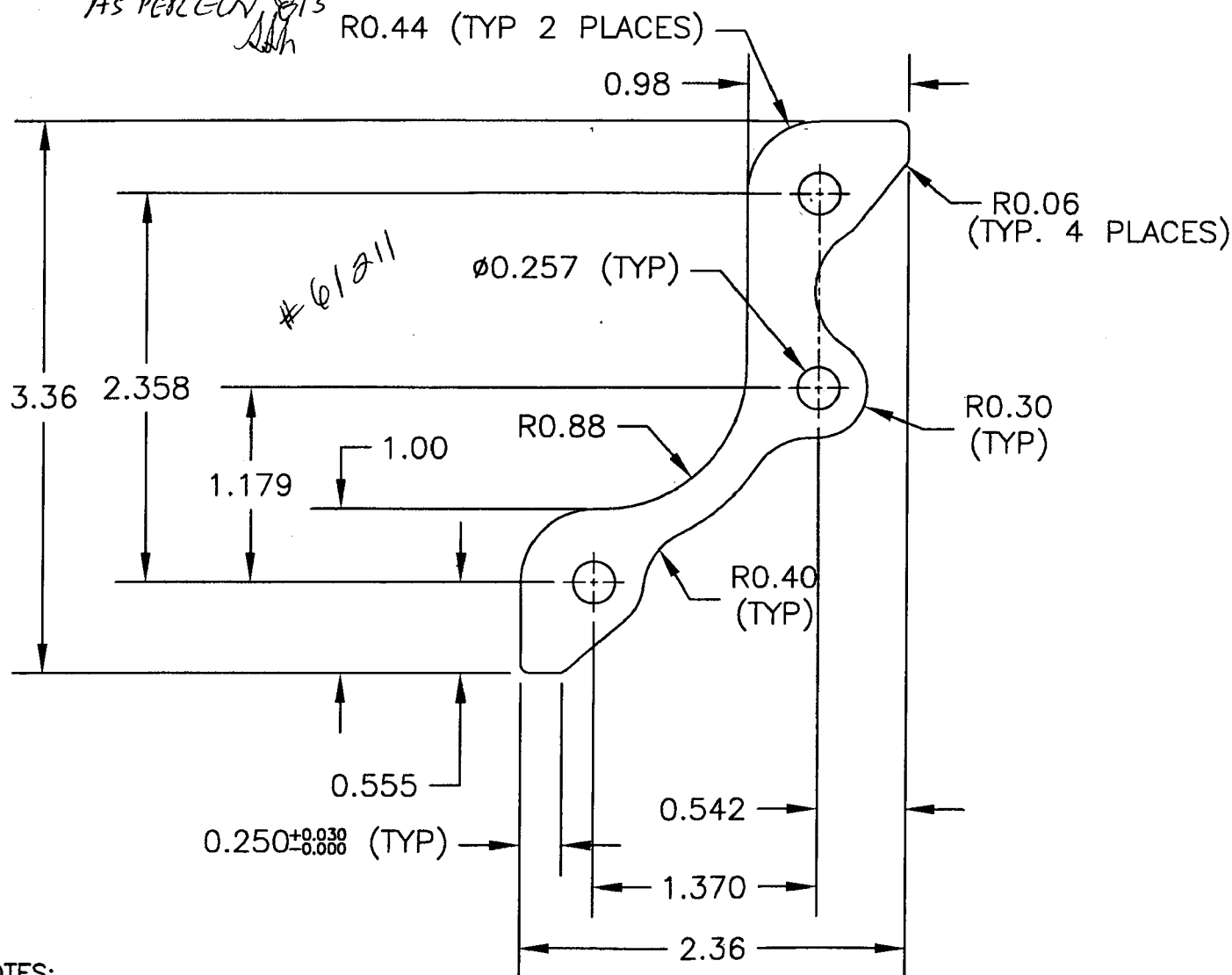
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RELEASED
06-06-21

AS PER ECN, 8/3



1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK
(REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK
(REF DART SPEC M5052H32S.125)

2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) BREAK ALL SHARP EDGES 0.010 TO 0.020

5) ALL DIMENSIONS ARE IN INCHES

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